

FIG. 1

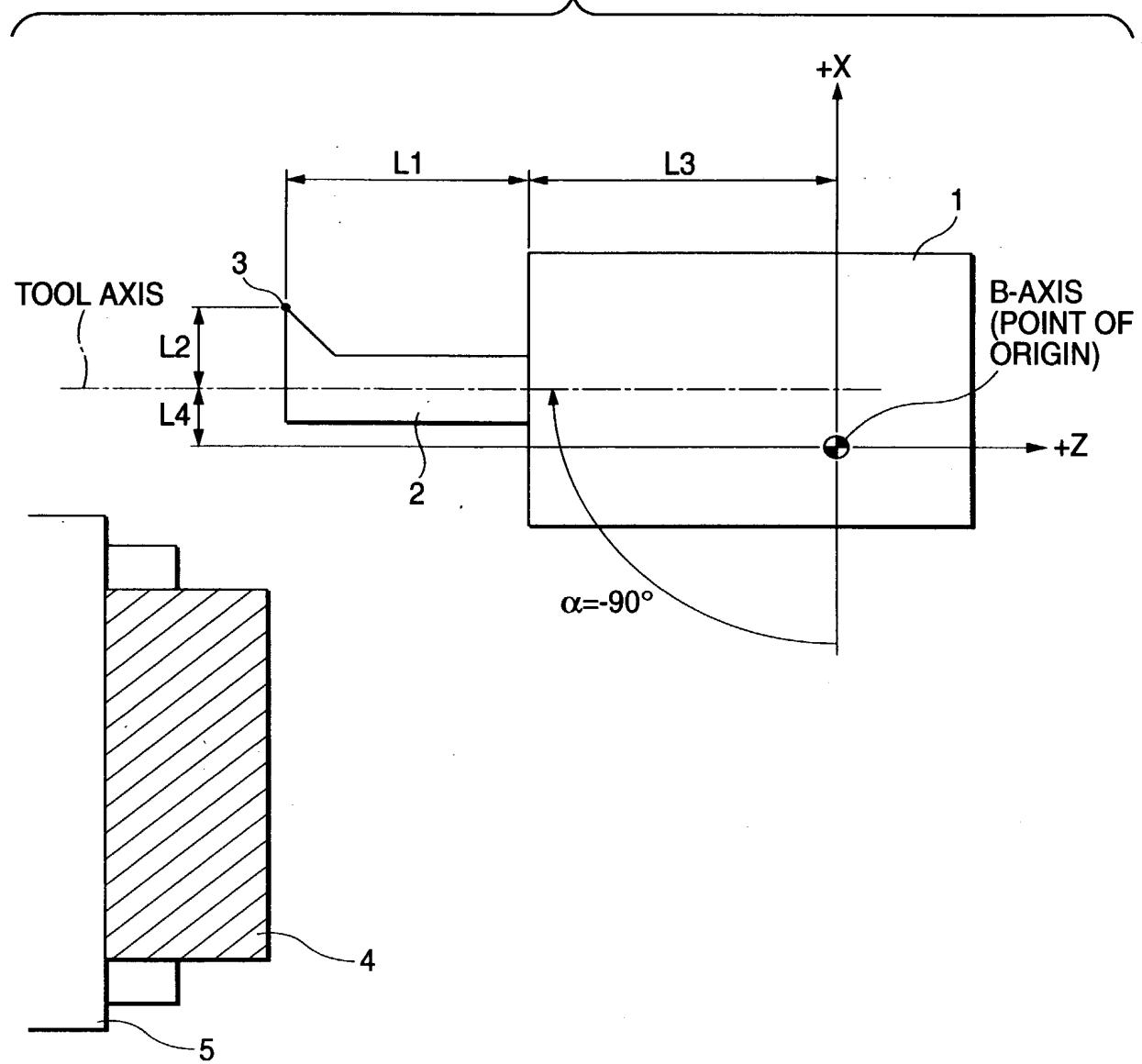


FIG. 2

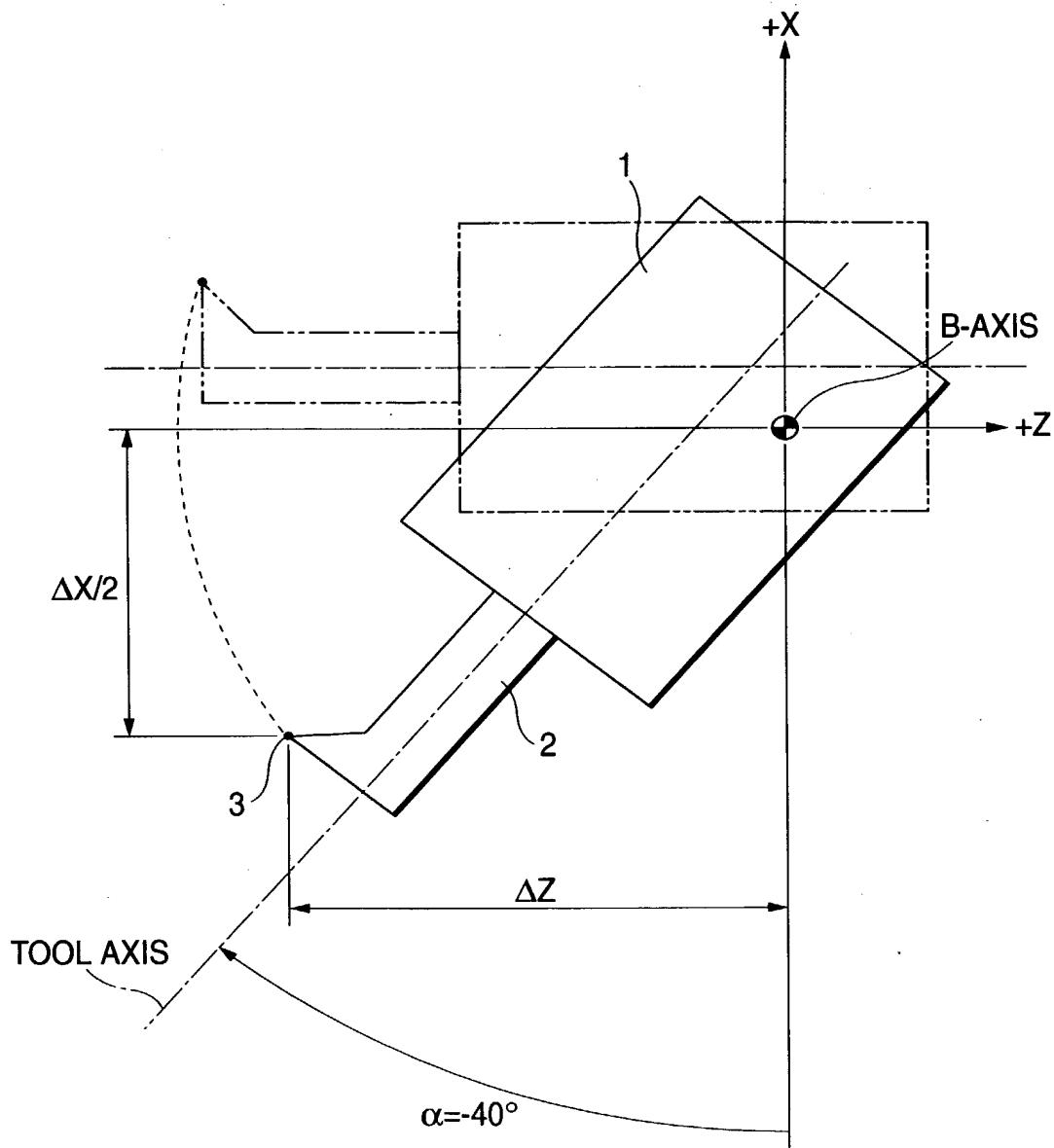


FIG. 3

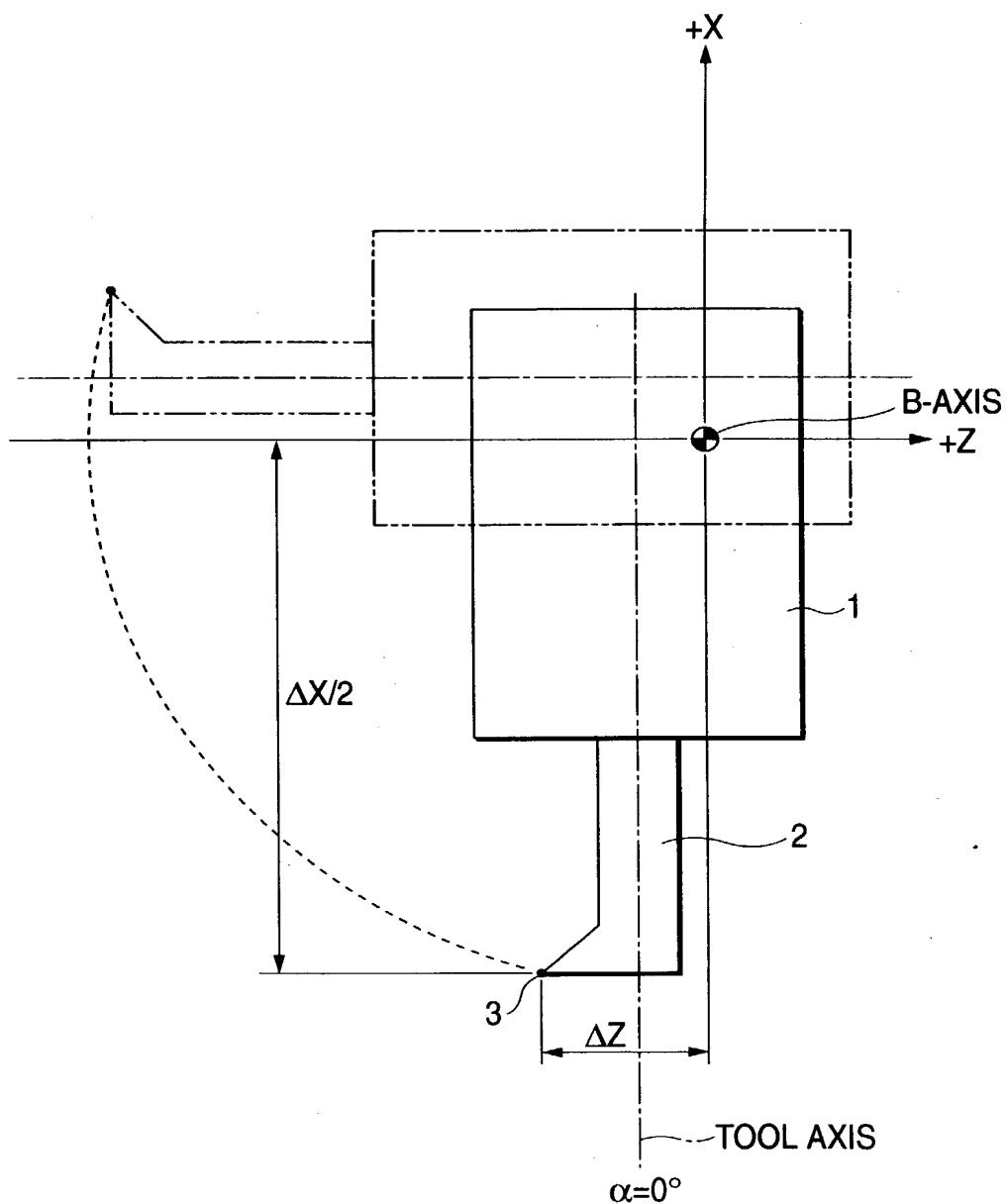
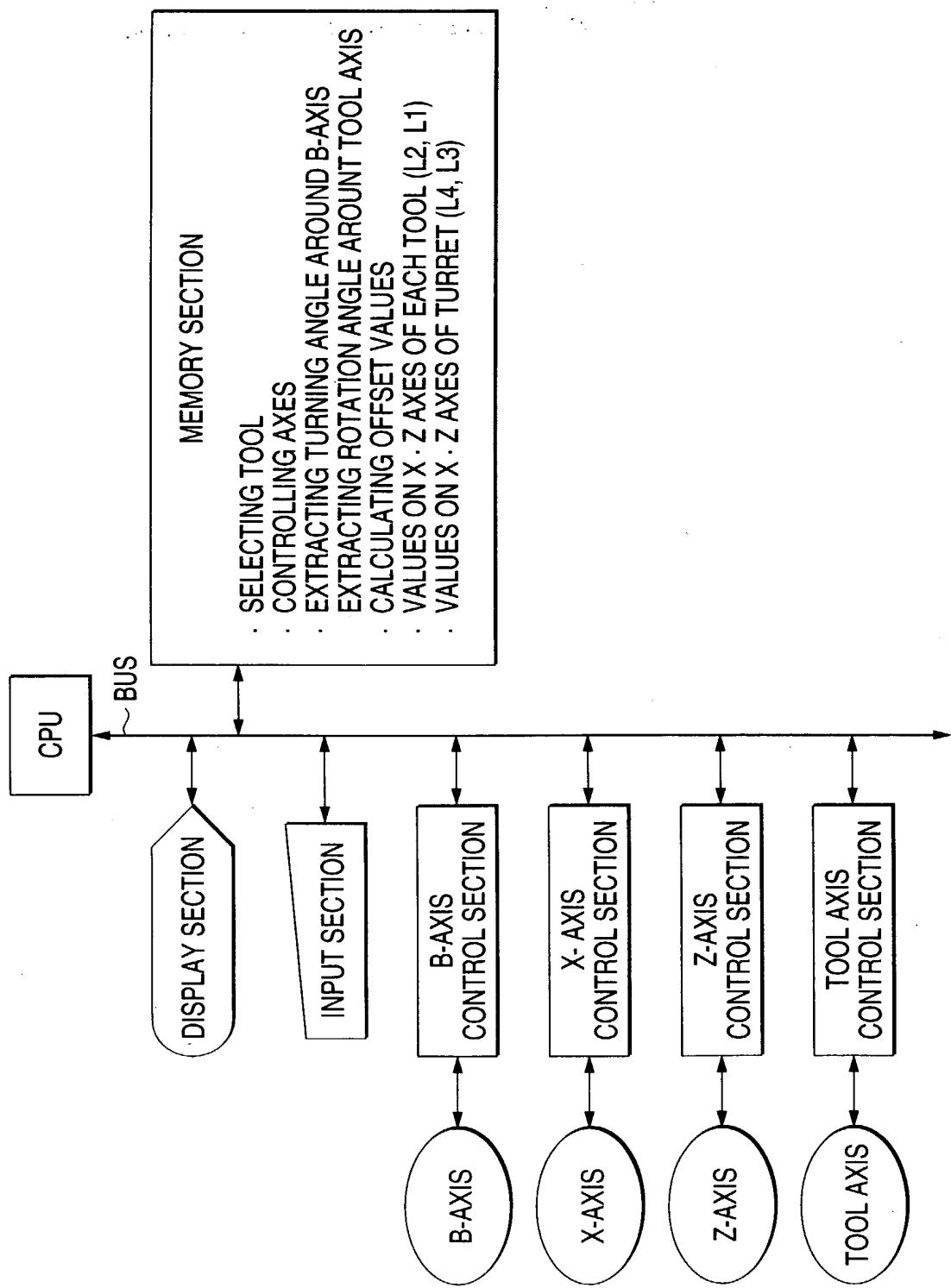


FIG. 4

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TOOL	TURNING ANGLE	OFFSET ON X AXIS (ΔX)	OFFSET ON Z AXIS (ΔZ)
1 TURNING (INITIAL POSITION)	-90.0°	-22.00 (ΔX_0)	400.00 (ΔZ_0)
2	-40.0°	598.69	265.54
3 (WEAR COMPENSATION VALUE)		ΔX_t	ΔZ_t
		-0.09 -0.24 -0.29	-0.04 -0.09 -0.14

FIG. 5

FIG. 6

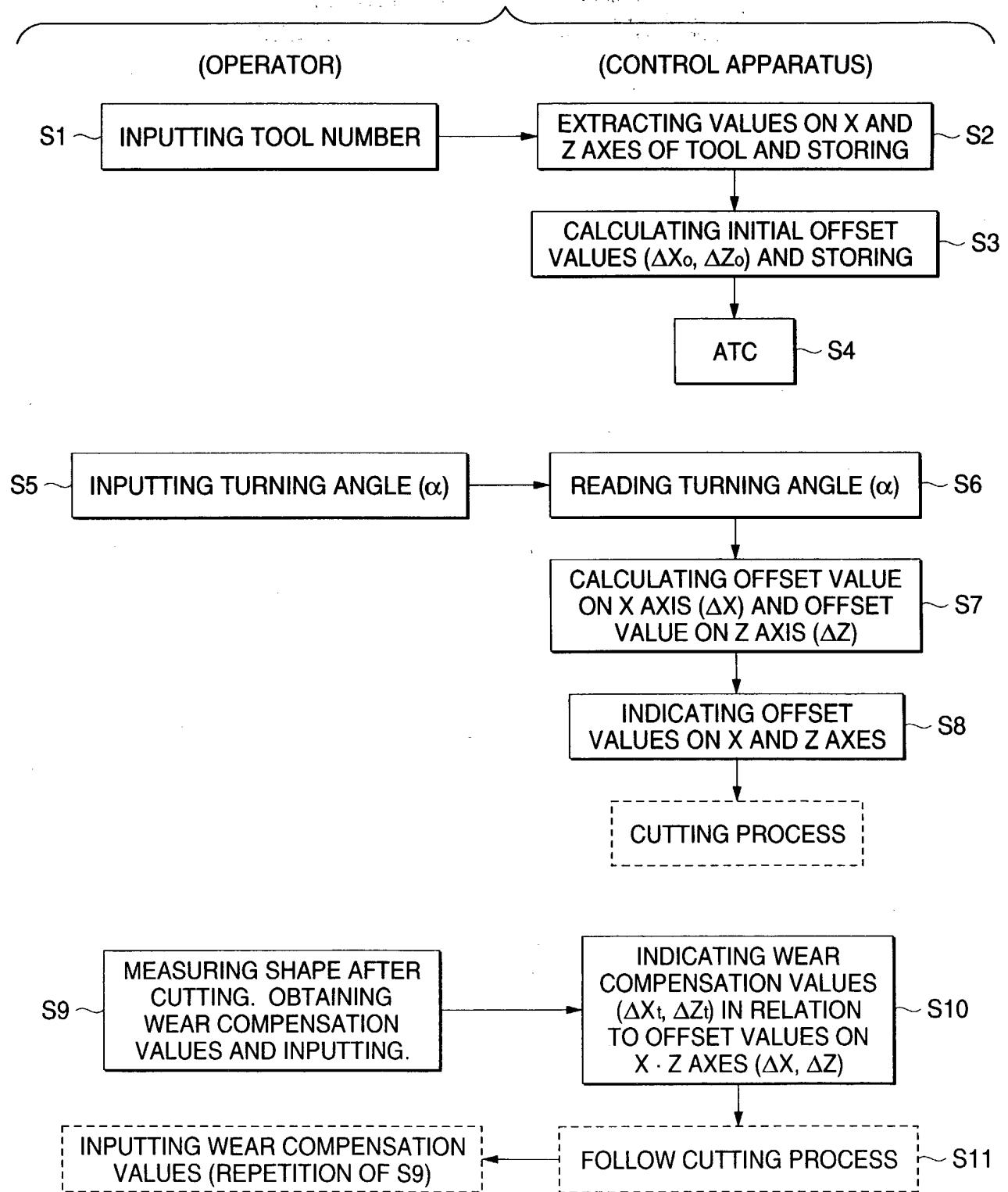


FIG. 7

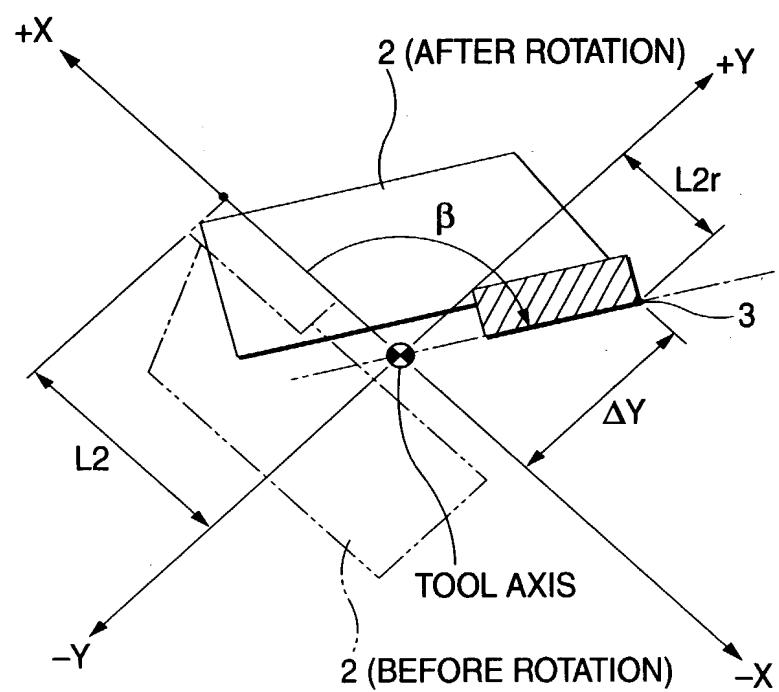


FIG. 8

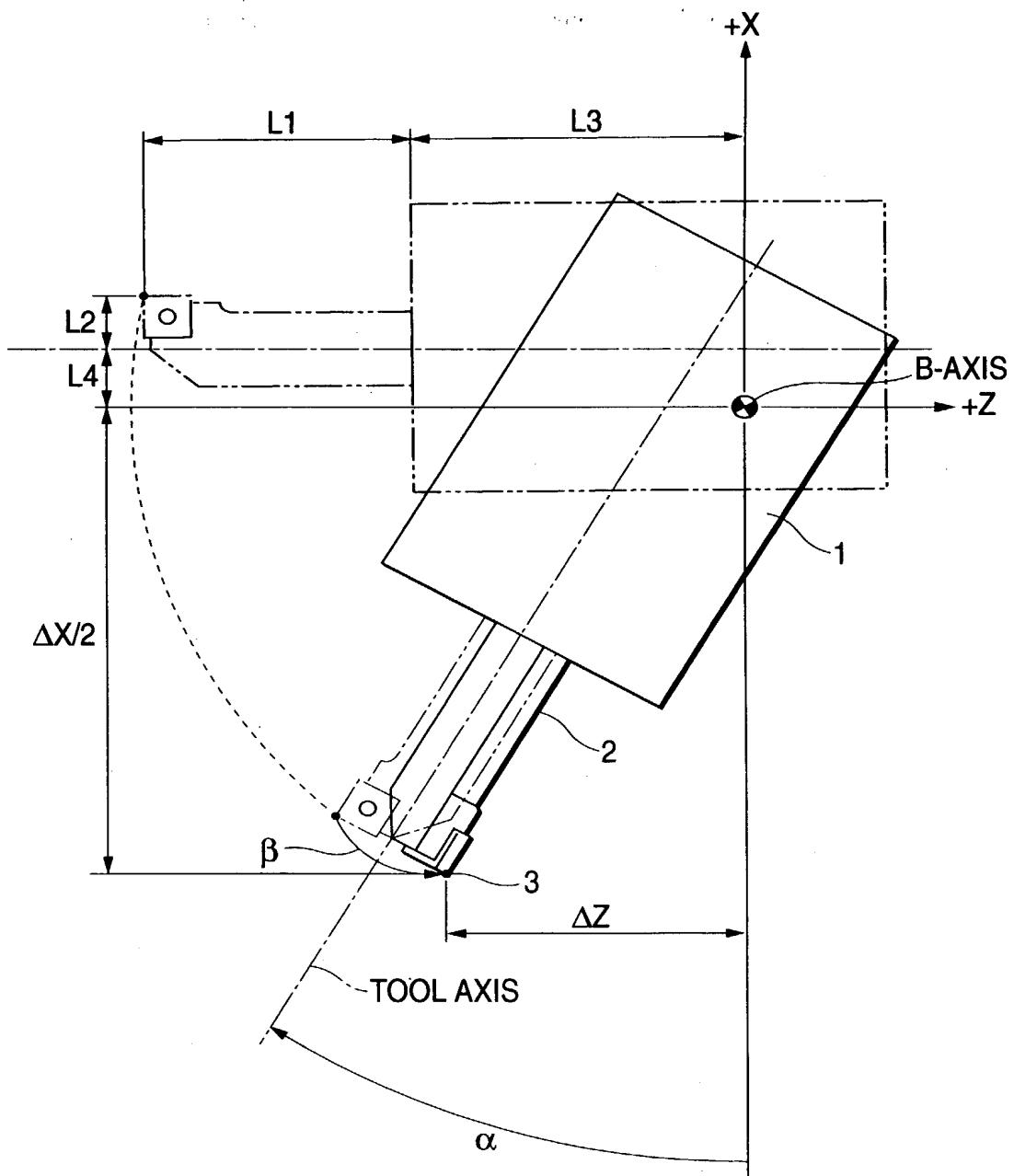


FIG. 9

TOOL	TURNING ANGLE (α)	ROTATION ANGLE (β)	OFFSET ON X AXIS (ΔX)	OFFSET ON Z AXIS (ΔZ)	OFFSET ON Y AXIS (ΔY)
TURNING (INITIAL POSITION)	-90.0°	0.0°	-22.00 (ΔX_0)	400.00 (ΔZ_0)	0.00 (ΔY_0)
	-40.0°	0.0°	598.69	265.54	0.00
	-40.0°	120.0°	617.98 (ΔX_t)	254.05 (ΔZ_t)	-8.66
		(WEAR COMPENSATION VALUE)	ΔX_t	ΔZ_t	ΔY_t
			-0.08 -0.13	-0.05 -0.10	-0.06 -0.10